

Work Order ID 52524

September 29, 2009 11:31:30 AM



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Item ID: D2435
Revision ID: E1
Item Name: Bearpaw, 206

Accept



Setup Start
Stop



Start Date: 29/09/2009 Start Qty: 12.00
Required Date: 16/10/2009 Req'd Qty: 12.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: RL Date: 09-9-29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

120	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
	CUT BLANK AS PER FILED2435								

B 9-10-10

130	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
	Memo	0.00							
	HAAS CNC vertical machine #1								
	1-Inspect material for defects or damage prior to machining								
	2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435								
	3-Deburr								

Y.A 09/10/15

12 0

12

140	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Quality Control								

Y.A 09/10/15

12 0

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Run Start
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: <u>PPP</u>	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

mt
29/10/16

12 *0*

PC 9/10/19 (12)

09/10/19

ME 09-10-19

Picklist Print

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Work Order ID: 52524

Parent Item: D2435RevE1

Parent Item Name: Bearpaw, 206



Comments:

Start Date: 29/09/2009

Required Date: 16/10/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	523.2231	38.4000			
<div>   </div>												
UHMW 1" Black												

18 9-10-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	446.5752	
112186	126.5752	
112514	200	
112681	120	112681
Main Warehouse		
ST	76.6479	
108762	11	
109186	5	
110520	8	
110721	10.5602	
111354	42.0877	

DART AEROSPACE LTD		Work Order: 52524
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.067x45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.203	✓			
D	R0.250	+/-0.030	R0.250	✓			
E	0.250	+/-0.010	0.253	✓			
F	0.625	+/-0.030	0.625	✓			
G	0.25 x 45°	+/-0.030	0.258x45°	✓			
H	0.375	+/-0.010	0.379	✓			
I	19.000	+/-0.030	19.000	✓			
J	0.950	+0.030/-0.010	0.959	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.930	+/-0.030	Ø0.924	✓			
M	0.30	+0.030/-0.000	0.307	✓			
N	0.375	+/-0.030	0.375	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.253	✓			
Q	2.000	+/-0.030	1.995	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by: Y.A	Audited by: mms	Prototype Approval: N/A
Date: 09/10/15	Date: 09/10/16	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

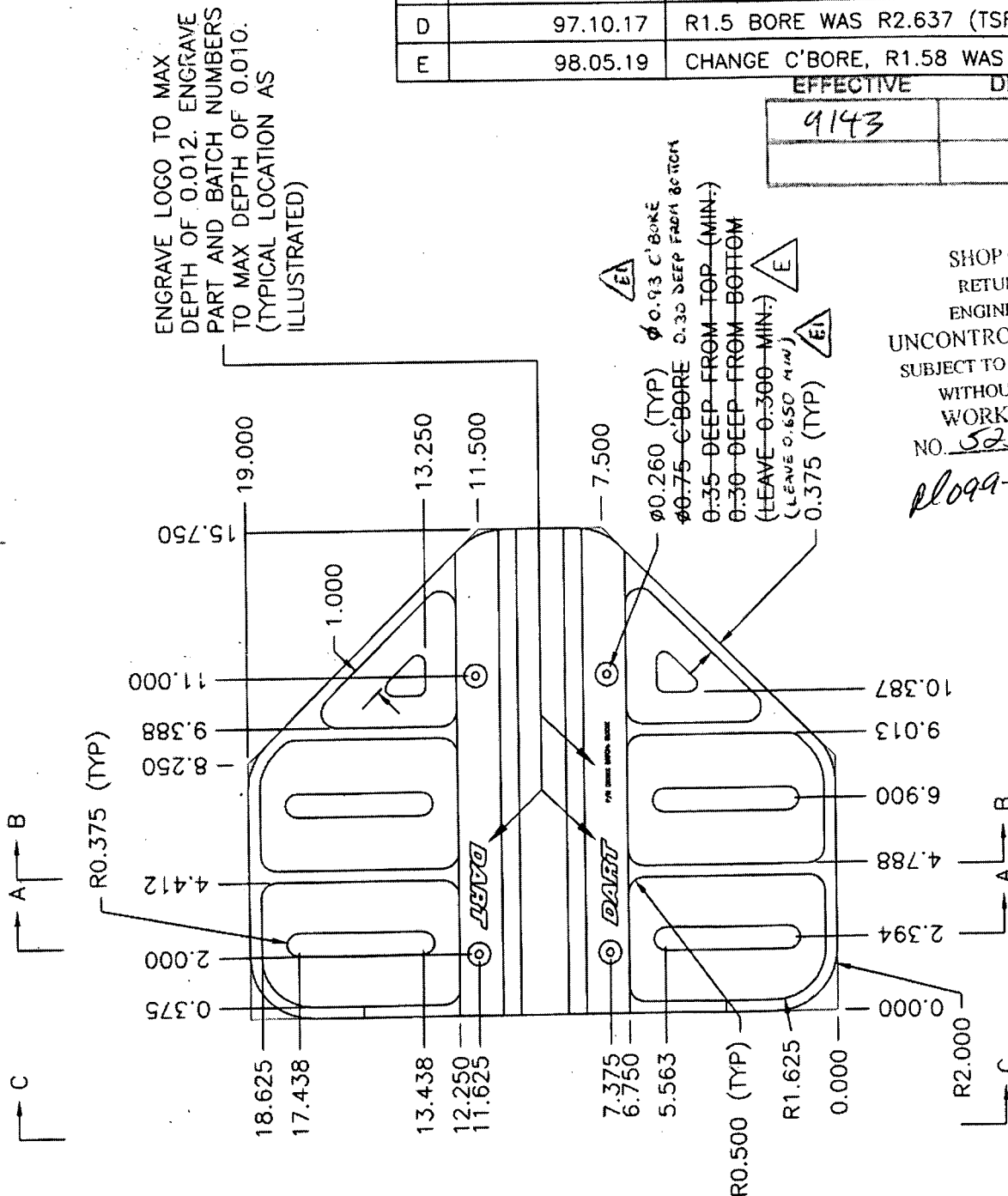
EFFECTIVE DEOS

9143	
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21099-20

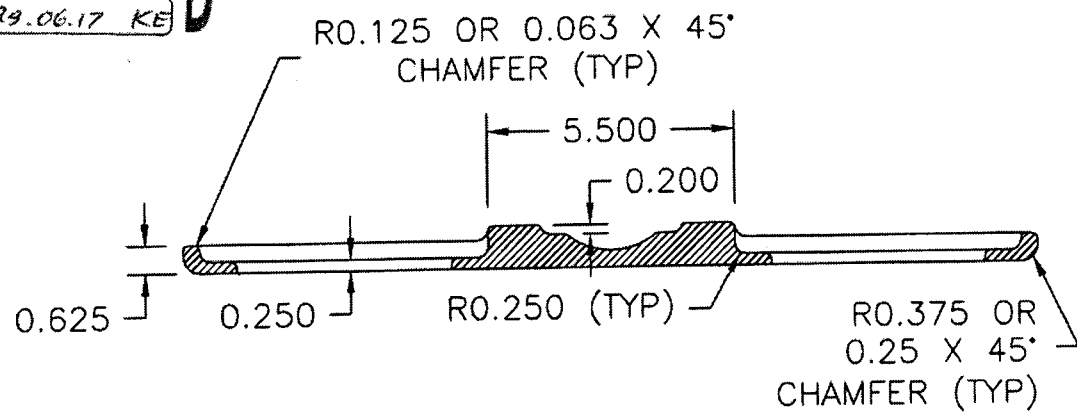
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING
1.00 THICK (MACHINE TO 0.950)



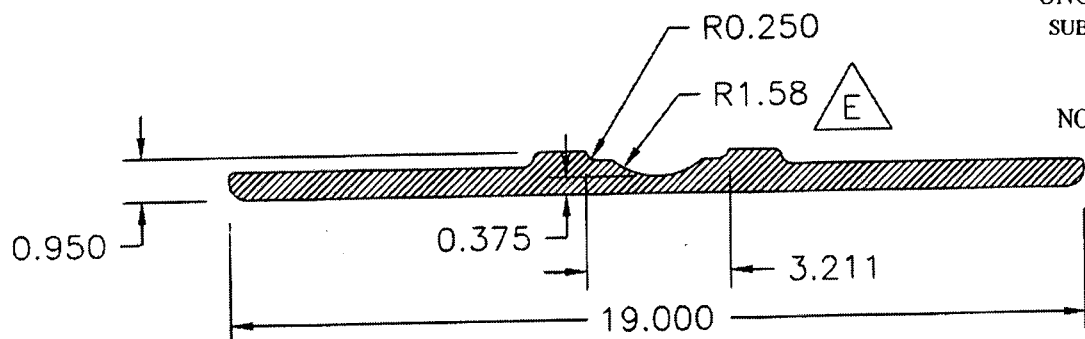


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

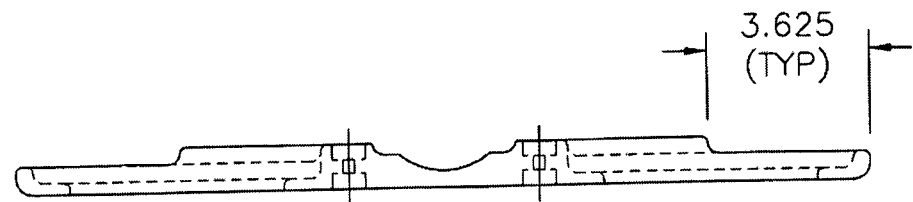
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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